

Work Order ID 72487

Tuesday, July 26, 2011 1:23:48 PM



Page 1

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 7/26/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: 11-07-24 Date: 11-07-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3274	D								
IIN-D206-642	Rev M								
100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-642-541		CHG003						

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foil 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: 1112860/m 115778

4- grind fwd cap weld on top surface only

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

11-7-29
11/08/04

11/08/08

11/08/08

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

114

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 uloslog

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8 uloslog

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Ac 11.08.10
Cpl 11.08.10

1 0

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 86-11/08/11

150

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☒ M117S16 ☐Sikaflex expire date: ☐ 12-1-5 ☐Start: ☐ 11-8-16 ☐ Time: ☐ 10:30 AMFinish: ☐ 11-08-16 ☐ Time: ☐ 8:00

(Adhere for 12 hours)

30% 11/08/11
DP 11-8-16

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/08/17

170

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297" . Deburr3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

BE 11/08/17

B 11/08/17

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11-8-17

190



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R ☐ Aluminum Rod ☐

M12860

8/6 11/08/17

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

8/5 11/08/17

11/08/17

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulost 17

210

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Sulost 17

④

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

1X Ø m-f 11/08/18

W/O:		WORK ORDER CHANGES					
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 9:30

OVEN TEMPERATURE: 320 OF

FINISH TIME: 10:00

0.00

240

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

250

HandFinishing

0.00



HandFinish

Memo

Hand Finishing

0.00

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

A/R ☐ N/A ☐ LPS-3 ☐ 1109956

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

A/R ☐ Sikaflex-291 ☐ 1117516Sikaflex expire date: ☐ 1510112 ϕ M 11/08/1181 ϕ M 11/08/1181 ϕ M 11/08/118

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC5- Inspect part completeness to step on W/O

0.00

Sikaflex



QC

Memo

0.00

Quality Control

Inspect Nut Plate & Inserts

270

HAND FINISHING RESOURCE #1

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R ☐ Sikaflex-291 ☐ 1117516Sikaflex expire date: ☐ 15101

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: 101A

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R ☐ Sikaflex-291 ☐ 1117516Sikaflex expire date: ☐ 15101

1 of 11 11/08/11

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Subtotal

Quality Control

②

290

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

PP 169-444

Packaging

11/8/18

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/19

11-08-19
①

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item Name: Replacement Skidtube



Start Date: 7/26/2011

Required Date: 8/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
 IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
 IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
 IPP Rev:F 08-06-02 add comment DD verified by:EC
 IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-1-190

Manufactured

No

110

Each

31.4000

1

1



Extrusion Round 3" 206



Location

Loc Qty

Loc Code

HALL

31.4

①

DP

11-7-29

59874

31.4

D3285-1

Manufactured

No

110

Each

102.0000

1

1



Cap



BE 11/8/08

Location

Loc Qty

Loc Code

LG002

102

52511

55

52647

47

D3282-041

Manufactured

No

150

Each

0.0000

1

1



Float Web (206L/407)



B69714

①

DP

11-8-16

W/O:		WORK ORDER CHANGES					
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Start Date: 7/26/2011

Required Date: 8/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

190

Each

52.0000

12

12



Cross Bolt Spacer



BE 11/08/17
B 72704 x12

Location

Loc Qty

Loc Code

LG

40

68224

2

71355

38

LG001

12

65317

1

68507

11

D3275-1

Manufactured No

190

Each

239.0000

12

12



Crossbolt Spacer



BE 11/08/17

Location

Loc Qty

Loc Code

LG002

239

66930

106

68946

72

70688

61

12

CR3212-4-03

Purchased No

250

Each

1,184.000

2

2



Cherry Rivet



M

11/08/18

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1182

114859

1182

x2

W/O:		WORK ORDER CHANGES					
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Start Date: 7/26/2011

Required Date: 8/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3415-041 Manufactured No

250 Each

59.0000

1

1



Nut Plate



u 11/08/18

Location

Loc Qty

Loc Code

ST053

59

33842

15

67605

44

x1

CCR264SS3-3 Purchased No

250 Each

477.0000

2

2



Cherry Rivet



u 11/08/18

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

475

117086

49

117849

426

v2

ALS4-1032-130 Purchased No

250 Each

2,772.000

78

78



Insert



u 11/08/18

Location

Loc Qty

Loc Code

ST281

718

117331

8

118386

710

ST282

2054

117717

54

118237

1744

118312

256

x78

Tuesday, July 26, 2011 1:23:55 PM

Shop Packet Print

Page 3

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Start Date: 7/26/2011

Required Date: 8/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-15 Manufactured No 270 Each 21.0000 1 1
Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	21	
66559	8	372881
71586	13	

Handwritten: 4108/18

D3536-23 Manufactured No 270 Each 33.0000 1 1
Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	33	
43406	1	
69902	20	
71579	12	

Handwritten: 4108/18

D3536-35 Manufactured No 270 Each 27.0000 1 1
Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	27	
69755	13	
71587	14	

Handwritten: 4108/18

D3536-39 Manufactured No 270 Each 30.0000 1 1
Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP015	30	
66241	4	
69760	26	

Handwritten: 4108/18

Tuesday, July 26, 2011 1:23:55 PM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 72487

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 7/26/2011

Required Date: 8/4/2011



Start Qty: 1.00

Required Qty: 1.00

D3535-15 Manufactured No 270 Each 20.0000 1 1
  1108118
Wearshoe



Location Loc Qty Loc Code

FP018 20
68358 6
69931 14

D3535-35 Manufactured No 270 Each 28.0000 1 1
  1108118
Wearshoe

Location Loc Qty Loc Code

FP018 14
65926 1
67598 1
70815 12
ST 14
69756 14

D3535-39 Manufactured No 270 Each 16.0000 1 1
  1108118
Wearshoe

Location Loc Qty Loc Code

FP018 16
64076 3
69759 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 72487

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 7/26/2011



Required Date: 8/4/2011

Start Qty: 1.00



Required Qty: 1.00

D3535-23 Manufactured No 270 Each 33.0000 1 1
 Wearshoe
 21 110818



Location	Loc Qty	Loc Code
FP021	33	
68342	5	
70818	16	
71581	12	



D3537-3 Manufactured No 270 Each 1.0000 1 1
 Wearpad
 21 110818

Location	Loc Qty	Loc Code
FP017	1	370481
35697	1	

D3537-1 Manufactured No 270 Each 44.0000 9 9
 Wearpad
 21 110818

Location	Loc Qty	Loc Code
FP017	44	
69817	5	
70686	2	369570
70972	37	

AN960C10L ~~NAS1149C0332~~ Purchased No 270 Each 0.0000 80 80
 washer
 1108306 1x801 21 110818

AN960C416 NAS1149C0463 Purchased No 270 Each 0.0000 1 1
 washer
 11117735 (x1) 21 110818

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 72487

Parent Item: D206-642-541

Parent Item Name: Replacement Skidtube

Start Date: 7/26/2011

Required Date: 8/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270 Each

914.0000 2 2



Phenolic Washer



HL

1108115

Location

Loc Qty

Loc Code

ST074

912

64177

416

66821

496

ST077

2

52505

2

VZ

AN3C4A

Purchased

No

270 Each

1,144.000 80 80



BOLT



HL

1108115

Location

Loc Qty

Loc Code

ST350

1144

117313

2

117688

187

117795

393

117872

22

118012

500

118112

40

111 118628 VSD

AN4C5A

Purchased

No

270 Each

500.0000 1 1



BOLT



HL

1108115

Location

Loc Qty

Loc Code

FP-B

106

112243

106

ST345

394

112243

394

11

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 72487



Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 7/26/2011

Required Date: 8/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2646

Manufactured No

270

Each

108.0000

1

1



Aft Cap



u10818

Location

Loc Qty

Loc Code

FP004

58

68280

58

FP006

5

62678

5

FP-4

38

70945

1

71070

37

fp5

7

71038

7

D3413-1

Manufactured No

270

Each

35.0000

1

1



Ring



u10818

Location

Loc Qty

Loc Code

ST420

33

62961

2

66387

1

70773

25

71041

5

ST473

2

66945

2

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72487

11/11/07-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

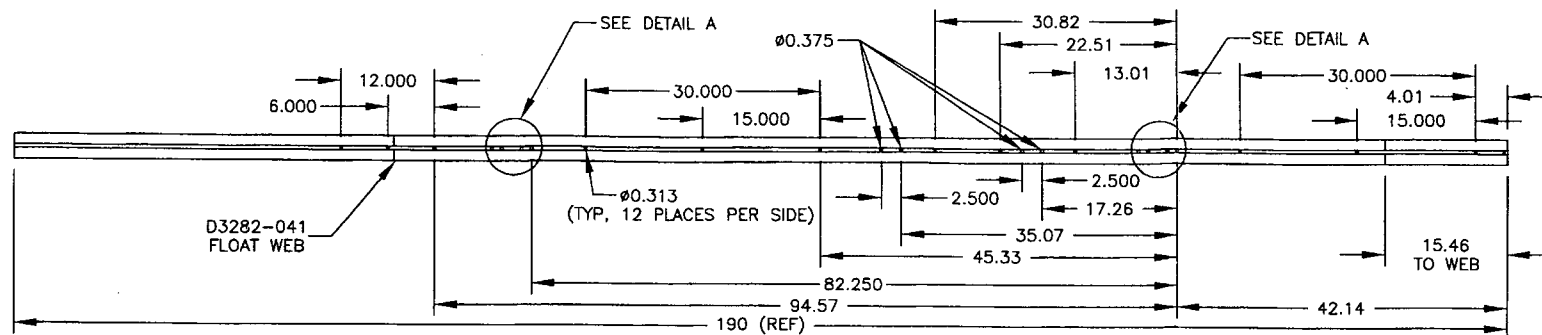
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

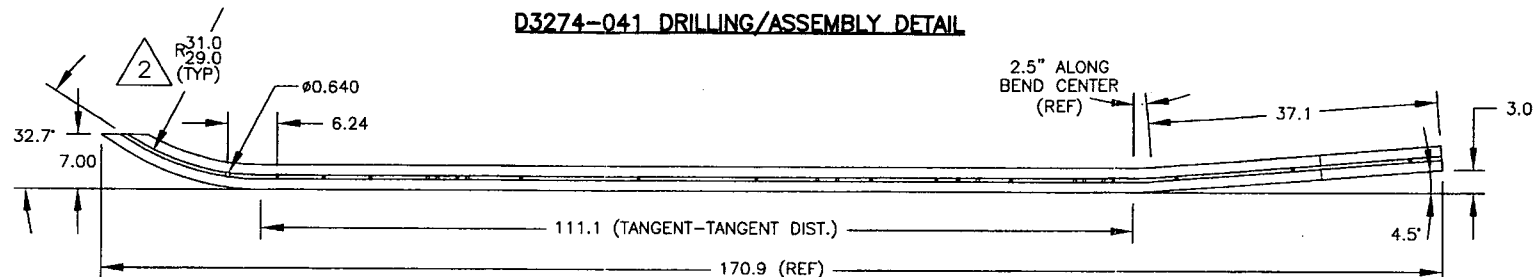
NOTE: Date & initial all entries

12487

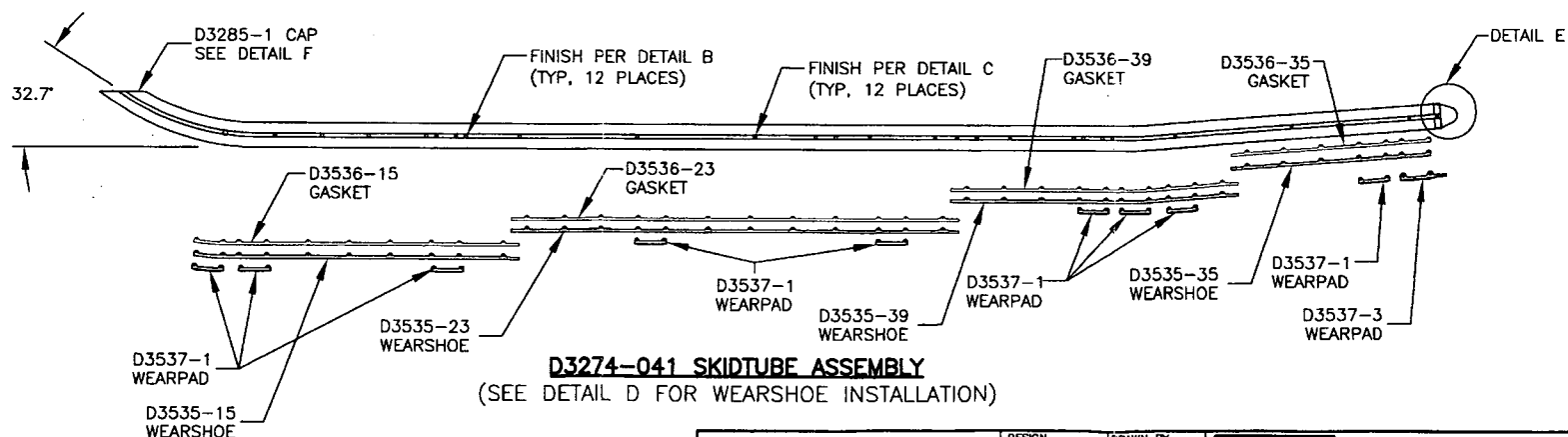
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. D
CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 2 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

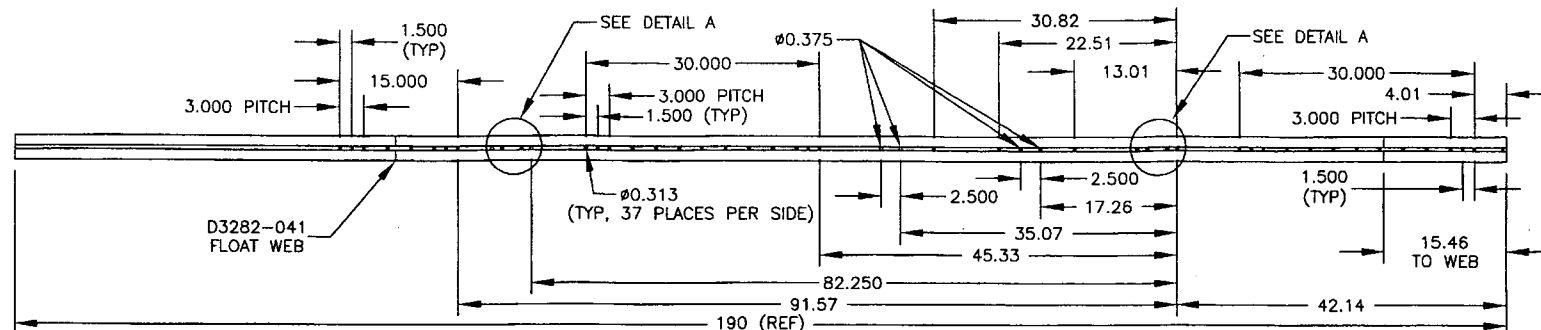
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

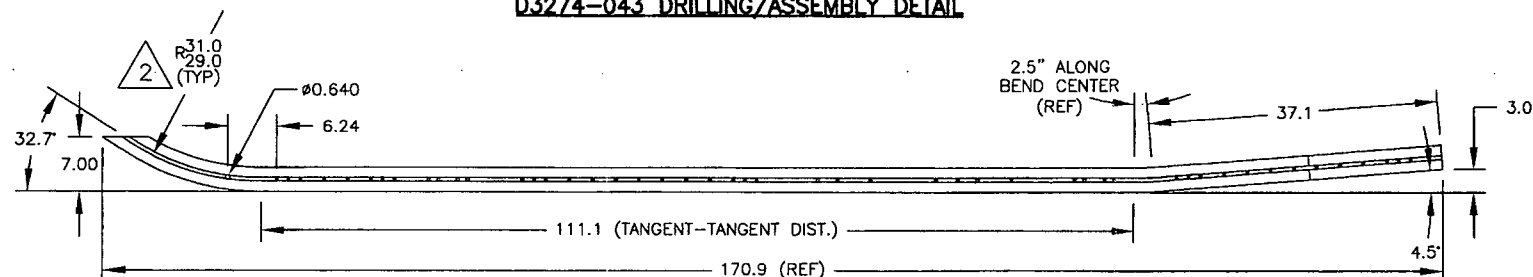
NOTE: Date & initial all entries

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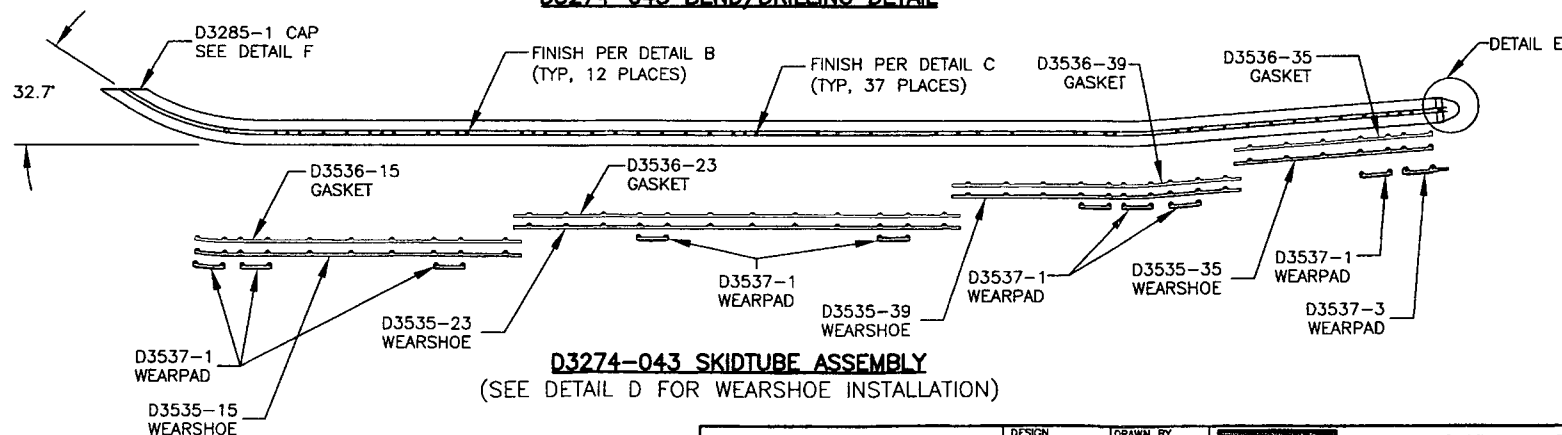
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

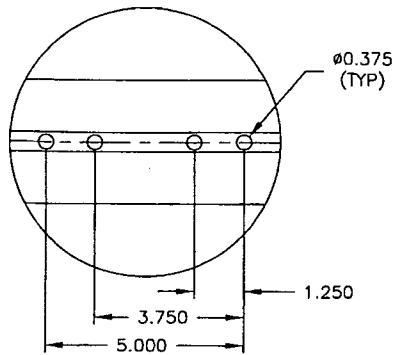
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

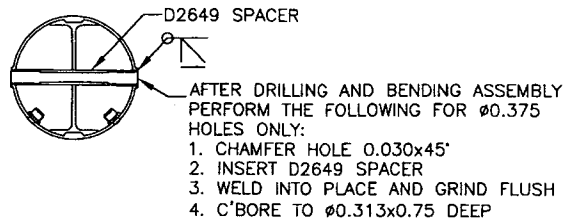
NOTE: Date & initial all entries

72487

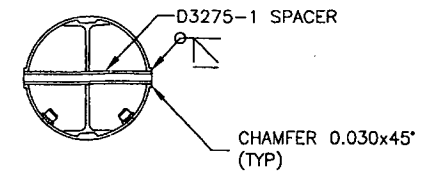
DETAIL A: DRILL DETAIL



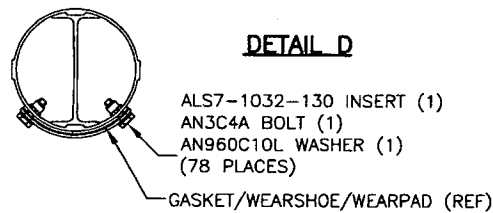
DETAIL B FOR 0.375 HOLES ONLY



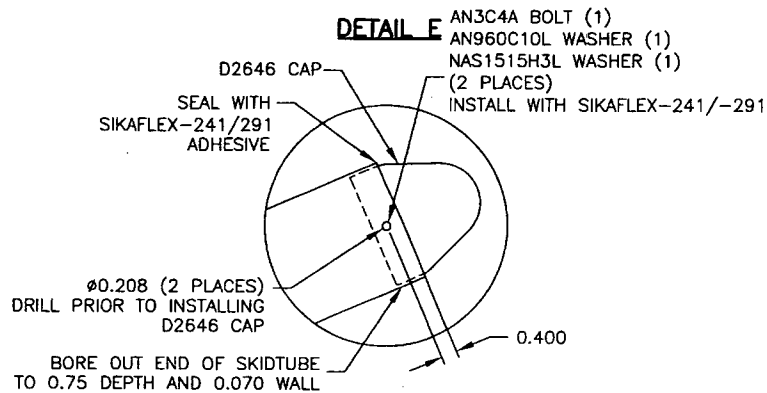
DETAIL C FOR 0.313 HOLES ONLY



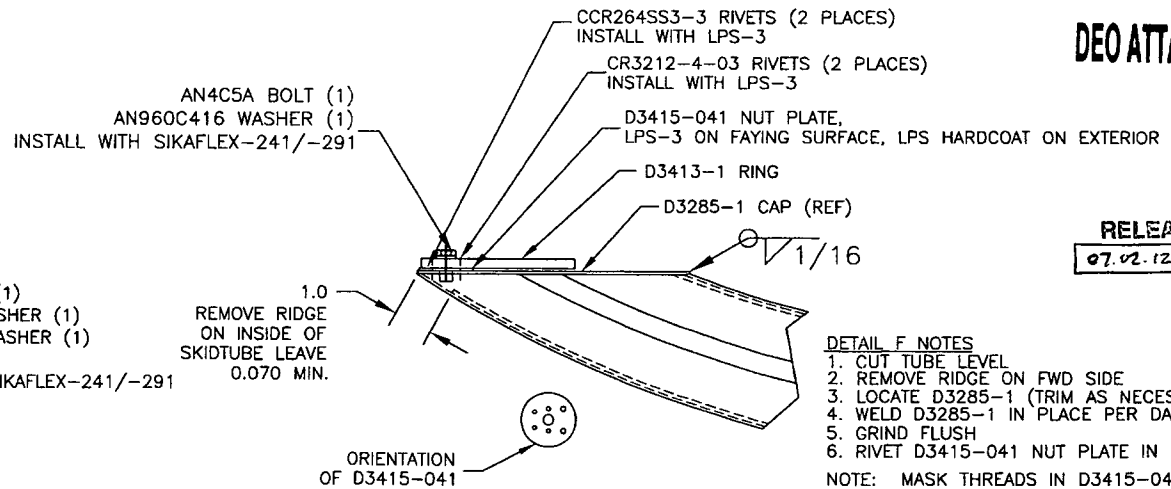
DETAIL D



DETAIL E



DETAIL F: END FINISHING DETAIL



DEO ATTACHED

RELEASED
07.02.12

- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

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DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

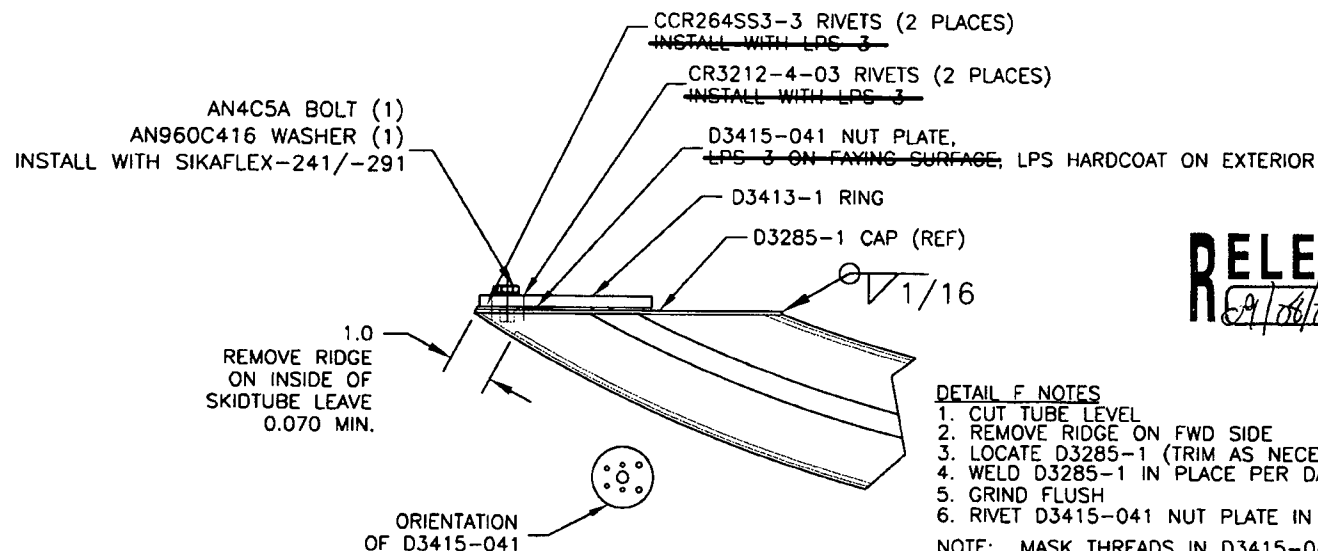
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

12487

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 261

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B69449
Part number: D206 642 541
Description: 206
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Sal Lewis Date of Test Coupon 11-08-11

Welder Barclay Elliott Date of Test Coupon 11-08-11

The above named individual is qualified in accordance with AWS D17.1.2001 to weld